

Date: Thursday, 12/7/2006 4:32:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 407 BASKET LID			
Job Number	: 29832B						
Estimate Number	: 10917						
P.O. Number	: N/A			Part Number	: D2952041		
This Issue	: 12/7/2006	S.O. No. : <u>1A</u>			Drawing Number	: D2952 REV B	
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A		Type	: LARGE FAB ASSY			
Previous Run	: 21174B			Drawing Revision	: B		
Written By	: <u>10 06 12 07</u>			Material	: N/A		
Checked & Approved By	: <u>10 06 12 07</u>			Due Date	: 12/19/2006		
Comment	: Est Rev:C 03.11.26 Reformat KJ/RF			Qty:	1	Um: Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6TS0750W062	6061-T6 SQ Tube.75x.062W	
		Comment: Qty.: 39.3750 f(s)/Unit Total : 39.3750 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.062" wall (M6061T6TS0.750W.062) Batch: <u>M9183</u>	
2.0	M5052H32S080	5052-H32 .080 Sheet	
		Comment: Qty.: 0.0656 sf(s)/Unit Total : 0.0656 sf(s) Material: 5052-H32/H34 (QQ-A-250/11 or QQ-A-250/8) 0.080" (M5052H32S.080) or 6061T6S080 (M6061T6S080) Batch: <u>M102783</u> Identify as D2952-11	
3.0	D2953077	Spacer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2953-077 Spacer <u>522095</u>	
4.0	D2953175	Spacer	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2953-175 Spacer <u>522096</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2957 Mounting Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
6	D2957	Mounting Plate	B21198

PD 06-12-18 (1)

6.0 M1100H14ES34X051F Alum Expanded Metal



Comment: Qty.: 15.7500 sf(s)/Unit Total : 15.7500 sf(s)

Pick:

Qty	Part Number	Description	Batch
15sf	M1100H14ES-3/4x.051F	Mesh	15444

PD 06-12-18 (1)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2952-11 corner gussets as per Dwg D2952

2-Drill holes in D2952-3 as per Dwg D2952.

3- Deburr & Remove any Markings From Material

4-Weld as per Dwg D2952 as per QSI 004. Deburr as required

A/R AL ROD Batch: M102421

PD 06-12-18 (1)

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06/12/19 (1)

9.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 06/12/19 (1)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PD 06-12-19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 02/21/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 D2983 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate B13263

① 06-12-19 (1)

12.0 MS20600AD4W2 Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Rivet M4747

① 06-12-19 (1)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/19 ①

14.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble Label Plate as per Dwg D2952

① 06-12-19 (1)

15.0 POWDER COATING POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005.4.3

Mflam

06/12/19 ①

16.0 QC3 INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

06-12-19 (1)

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA



① 06-12-19 (1)

18.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

① 06/12/20

Job Completion



① 06/12/20

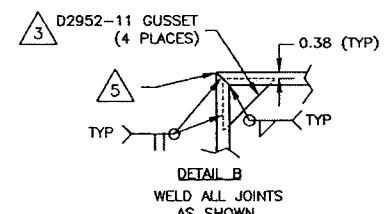
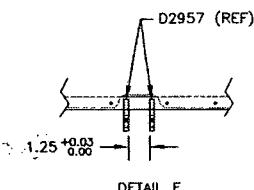
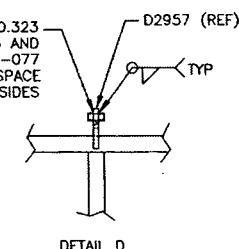
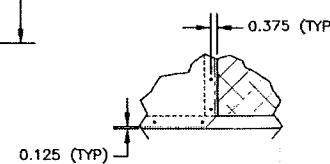
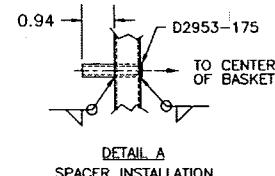
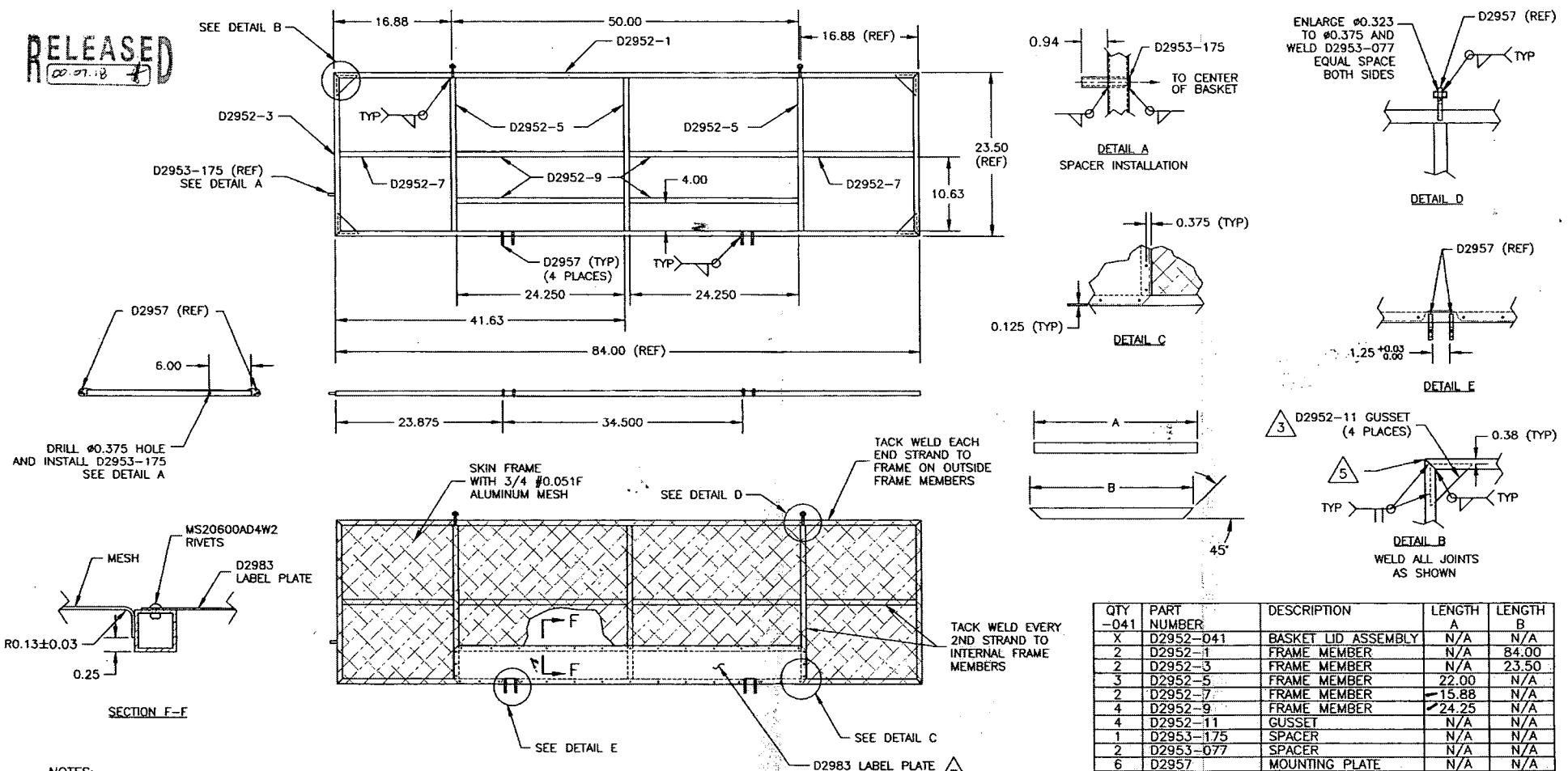
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
DD-07-13



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
X	D2952-041	BASKET LID ASSEMBLY	N/A	N/A
2	D2952-1	FRAME MEMBER	N/A	84.00
2	D2952-3	FRAME MEMBER	N/A	23.50
3	D2952-5	FRAME MEMBER	22.00	N/A
2	D2952-7	FRAME MEMBER	15.88	N/A
4	D2952-9	FRAME MEMBER	24.25	N/A
4	D2952-11	GUSSET	N/A	N/A
1	D2953-175	SPACER	N/A	N/A
2	D2953-077	SPACER	N/A	N/A
6	D2957	MOUNTING PLATE	N/A	N/A
1	D2983	LABEL PLATE	N/A	N/A
34	MS20600AD4W2	RIVETS	N/A	N/A

B	00.07.06	CHANGE FROM SHEET TO MESH; ADD D2952-7/-9/-11
A	00.01.14	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED RF	APPROVED RF	DRAWING NO. D2952
DATE 00.07.06	REV. B SHEET 1 OF 1 TITLE BASKET LID ASSEMBLY NTS	

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WITHOUT NOTICE
WORK ORDER
29832 B

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